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D2435

Job Sheet 176122



Part No: D2435

Job Qty: 8 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/17/18

Job Tracking No:

Due Date: 4/30/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		4/27/18	0.00	0.00	Start Up Container		18/04/17
120	Waterjet	8 pcs		4/27/18	0.00	1.33	Waterjet 2 OMAX		18/04/17
130	CNC Vertical Machining	8 pcs		4/30/18	0.41	8.11	HAAS 1		52 18/06/25
150	QC	8 pcs		4/30/18	0.00	0.00	QC8		8/06/28
151	Packaging	8 pcs		4/30/18	0.00	0.00	Packaging3		8/06/28
190	QC21-SA	8 Ea		4/30/18	0.00	0.00	QC21		8/06/28

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	25.6000 sf (3.2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	26	1,818	0

DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐ Scrap ☐		Skid-tube Machine ☐		Cross tube ☐	
NCR No. _____						Water Jet ☐ g. Coord. ☐ cKaging ☐ upplier ☐	
Date: _____						Engineering ☐ Quality ☐ Other ☐	
Description Wor						MRB (QSI042) Approval	
						Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Container No: S062086		Part: D2435	
		Job No: 176122	
		Serial No/Batch: S062086	
		Revision:	
		Inspector:	

Date: 04/17/10

Centre Not Concentric	☐	Set-up	☐	Folio/Program	☐	Positioned Wrong	☐
Cracks	☐	BOM/Route	☐	Grain	☐	Outside Dimensions	☐
Crimp/Kink/Ripple/Wave	☐	Broken/Damage/Defect	☐	Weld	☐	Over/Under tolerance	☐
Cuffs	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Incorrect	☐
Crushing	☐	Contamination	☐	Out of Sequence	☐	Part Lost/Missing	☐
Heat Treat	☐	Countersink	☐	Off-set	☐	Part Moved	☐
Wave/Twist in Tube	☐	Cut Too Short	☐	Mislabeled	☐	Drawing	☐
Marks/Chatter	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Finish	☐
	☐	Drill Holes	☐	Misaligned/off center	☐	Mistread	☐
	☐		☐		☐	Turning Sequence	☐

OTHER : _____

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		0.063
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	45°
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		5.500
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		0.200
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	0.250
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		R.0.250
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595		0.625
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240		0.250
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle	45°
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365		0.380
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970		19.000
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940		0.955
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter	0.260
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter	0.930
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300		0.315
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345		0.380
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345		7.375
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240		4.250
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970		2.000
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990		9.000
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720		15.750